

Date: Tuesday, 20/05/2008 12:44:42 PM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: WEARSHOE
<b>Job Number</b>	: 39346		
<b>Estimate Number</b>	: 13315		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D37933
<b>This Issue</b>	: 20/05/2008	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: PRELIM
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 39278	<b>Drawing Revision</b>	: PRELIM
	<b>Type</b> : R & D SM/MED FAB	<b>Material</b>	:
<b>Written By</b>	: <u>                    </u>	<b>Due Date</b>	: 27/05/2008
<b>Checked &amp; Approved By</b>	: <u>                    </u>	<b>Qty:</b>	2 Um: Each
<b>Comment</b>	: Est Rev:A 08-05-13 new issue DD verified by:EC		

Additional Product

PRELIMINARY ISSUE

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304S20GA	304/316 .040 Sheet
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**Comment:** Qty.: 1.3545 sf(s)/Unit Total : 2.7090 sf(s)

304/316 .040 Sheet

(M304S20GA)

Batch: 107909 08 8-5-20

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3793

Dwg Rev: PFEProg Rev: PFE

2-Deburr if necessary

08 8-5-20

NEW .DXF

D3793-3 UPDATED

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECKused as prototype only

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

1-Deburr if necessary

2-Form on Brake as per Dwg D3793 using Jigs

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 39346

Part Number: D37933

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING  
APPROVAL**

**ENGINEERING  
APPROVAL**

Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3

START TIME: \_\_\_\_\_

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: \_\_\_\_\_

N/A

PT 08.05.22

NOT FOR STOCK

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

PT 01.05.22  
STOCK AS PROTOTYPE

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



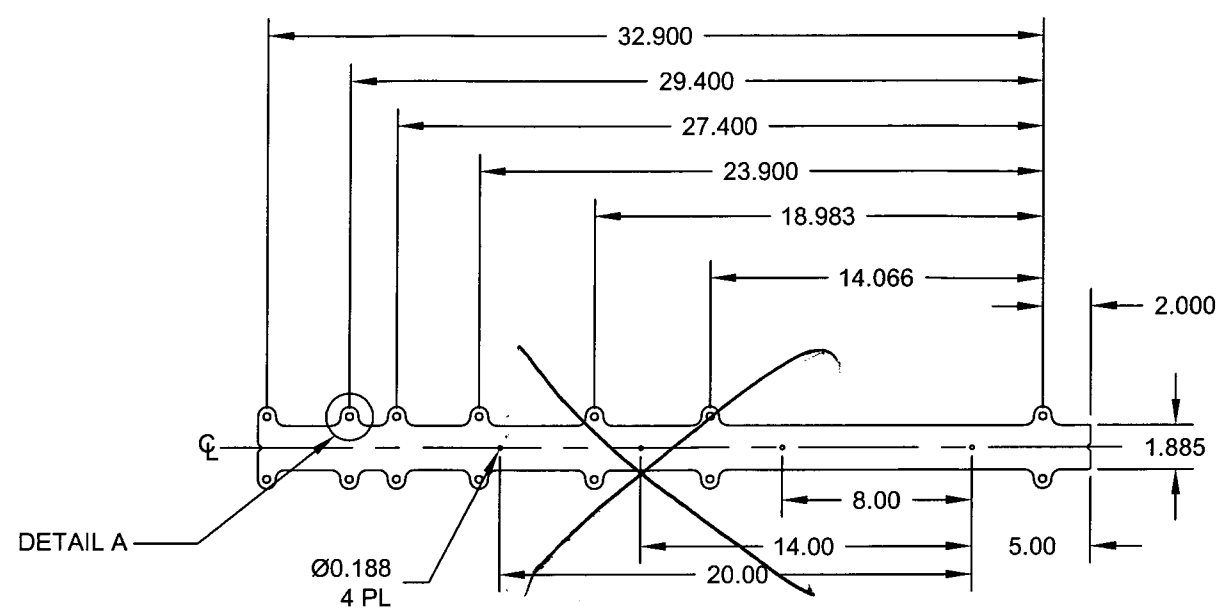
POSITIVE RECALL

EFFECTIVE

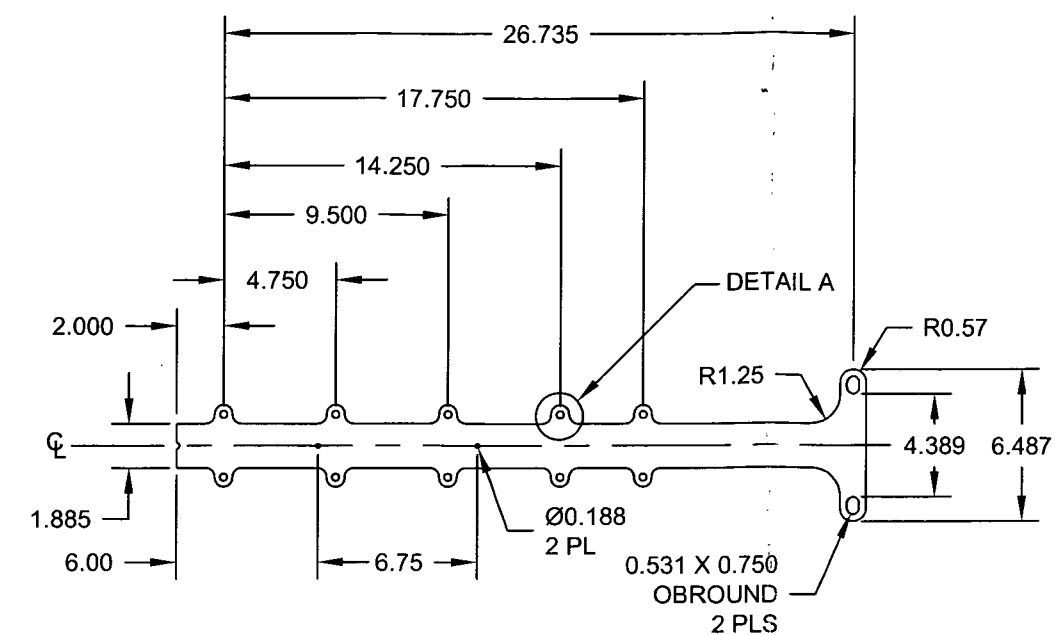
RELEASED

AUTH

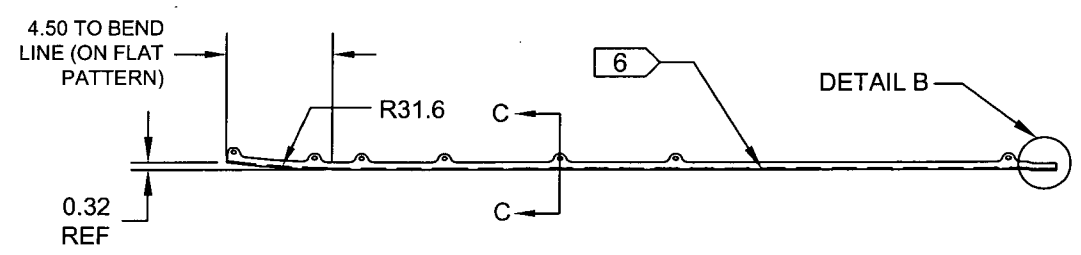
DATE



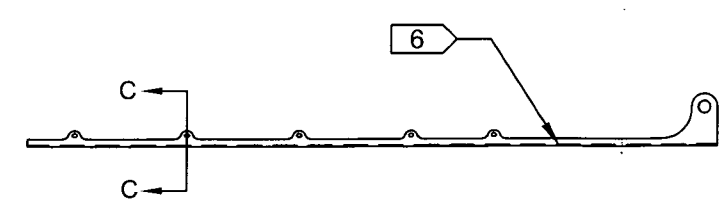
**D3793-1F FLAT PATTERN**



**D3793-3F FLAT PATTERN**



**D3793-1 BEND DETAIL**  
(MAKE FROM D3793-1F)

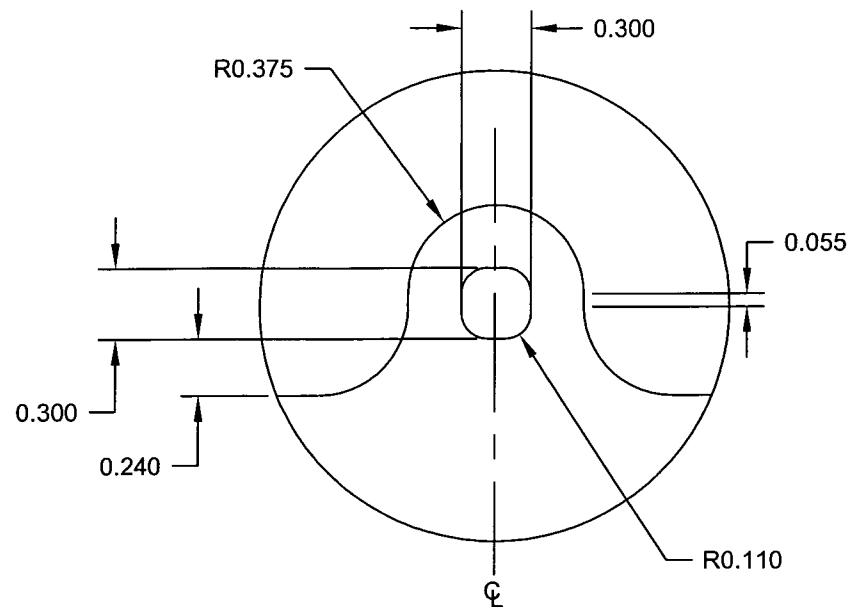


**D3793-3 BEND DETAIL**  
(MAKE FROM D3793-3F)

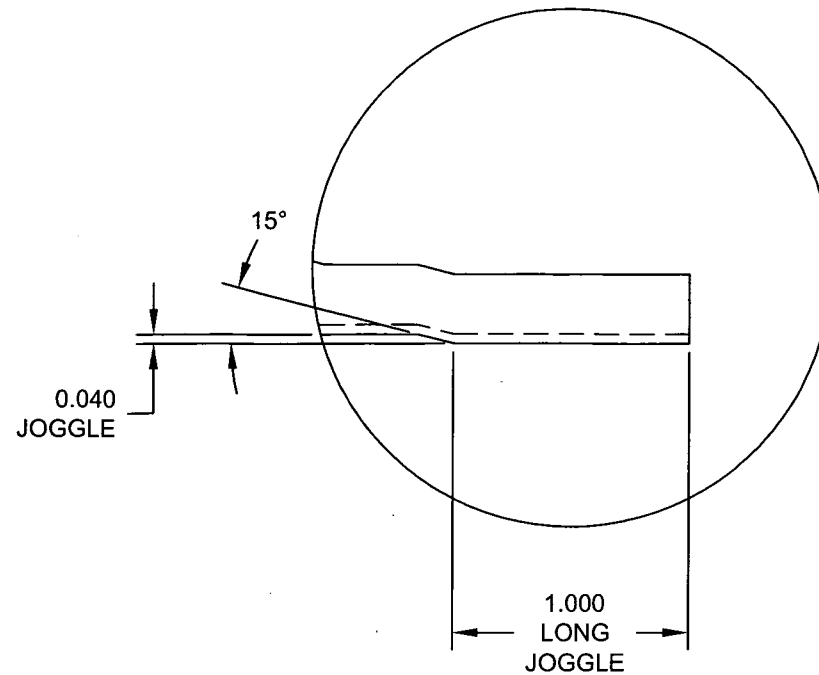
**PRELIMINARY ISSUE**  
REV 08.05.20

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
  - 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
  - 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

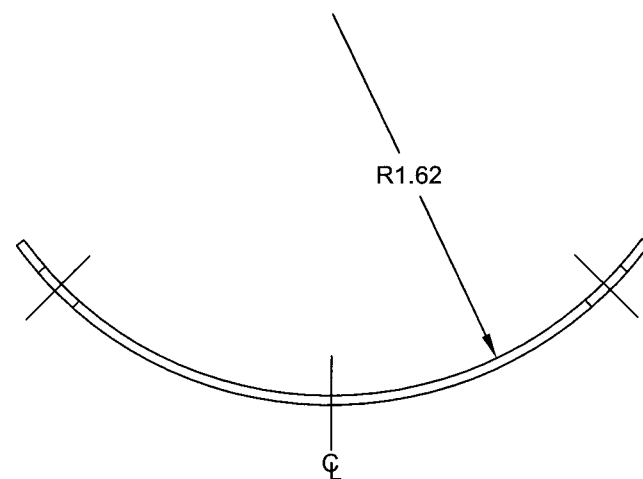
A	NEW ISSUE	PH	08.05.14
REV.	DESCRIPTION	BY	DATE
DESIGN	1	<b>DART AEROSPACE USA, INC</b>	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3793	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE	NTS
DATE	08.05.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



**DETAIL A**  
SCALE 10X



**DETAIL B**  
SCALE 10X



**SECTION C-C**  
SCALE 10X

**PRELIMINARY ISSUE**  
PA 01.05.20

DESIGN		<b>DART AEROSPACE USA, INC</b>	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3793	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE	NTS
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